

Date
UserTuesday, 19/08/2008 4:07:23 PM
Julie Lecocq

Process Sheet

TALMAR

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 90 DEGREE COVER PLATE

Job Number : 41511 -1

Estimate Number : 13405

P.O. Number :

This Issue : 19/08/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run : 40069

Part Number : PB674300169

Drawing Number : B6743001 PAGE25

Project Number : N/A

Drawing Revision : B1

Material :

Due Date : 18/09/2008

Qty: 30 Um: Eac

Written By : JUL 08.8.20Checked & Approved By : JUL 08.8.20
Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M6061T6S032

6061-T6 Sheet 0.032"

Comment: Qty.: 1.4234 sf(s)/Unit Total: 42.7014 sf(s) 18147
6061-T6 Sheet 0.032" 18 8-9-8

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001

Dwg Rev: B1 18 8-9-8

Prog Rev: B1

****grain direction along 9.144" ****

2-Deburr if necessary 18 8-9-8

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg B67-43001

S 02/02/09 136 counter

S 28/09/10 10

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

8 08/09/10 xlv

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg B67-43001

Pn

12 08.09.15 10

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1- grind weld flush

9.0	QC10	VISUAL INSPECTION OF GROUND WELDS
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Comment: VISUAL INSPECTION OF GROUND WELDS

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Scanned

12.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-69 PAR #: PIA Fault Category: Prod/Ins. Mfg NCR: Yes No DQA: A Date: 08/10/09
 Resolution: _____ Disposition: _____ QA: N/C Closed: A Date: 08/10/09

NCR: <u>41511-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/15	# 80	All 10 parts scrap due to welder trying to weld parts together without proper tooling.	08/09/15	parts are too badly bent into shape → make tool to form part correctly	08/09/15	08/09/15	08/09/15	08/09/15
						08/09/15		

NOTE: Date & initial all entries

1914
Jan 1st

at 10:00

for 10:00

1914

Process Sheet

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Job Number: 41511

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Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-18

NO 4351

WORKSHEET

WITHOUT NOTICE

SUBJECT TO AMENDMENT

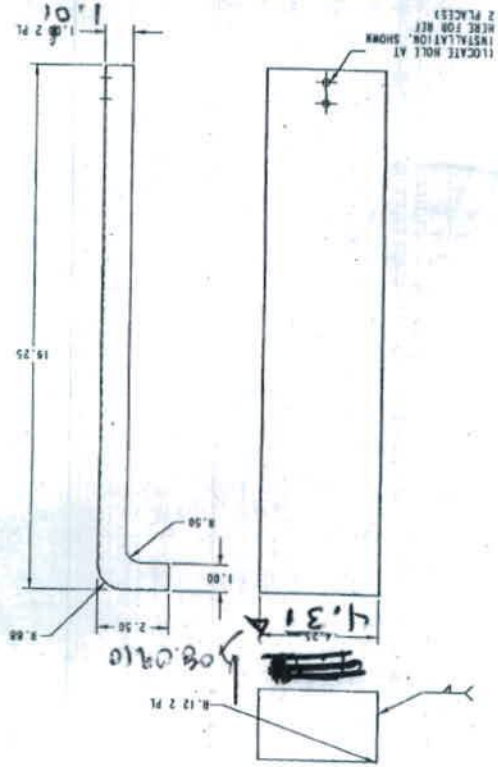
UNCONTROLLED COPY

ENGINEERING

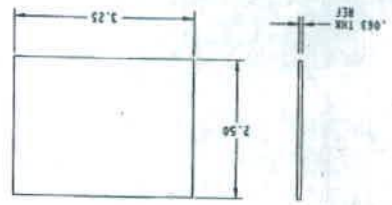
RETURN TO

SHIP COPY

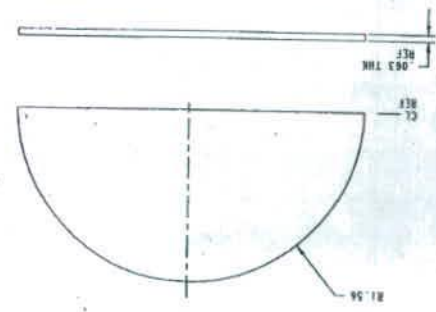
② -69 90 DEGREE COVER PLATE
MATERIAL: .062 THK, 6061-T6, QQ-A-250/11
SCALE: 8:500



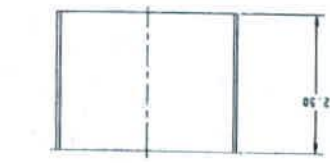
⑥ -185 D-PAD BACK PLATE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE: 1:800



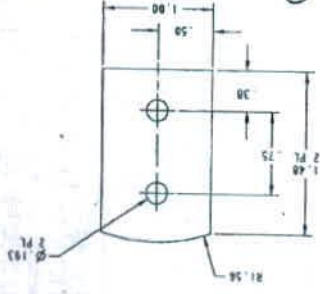
⑧ -339 D-PAD TOP
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE: 2:800



③ -189 D-PAD FACE
MATERIAL: .063 THK, 6061-T6, QQ-A-250/11
SCALE: 1:800



④ -193 D-PAD BASE
MATERIAL: .125 THK, 6061-T6, QQ-A-250/11
SCALE: 2:800



RELEASED

ORIGINAL

PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75052
DPO SUYB B67-43001
REV 100

RT AEROSPACE LTD		Work Order:	41511
Description: 90° COVER PLATE		Part Number:	PB6743001-69
Inspection Dwg: Rev: B1		Page 1 of 1	

X	First Article	X	Prototype
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